١	N۵	ark	Org	ler	ID '	12	6802
٦	' Y U	JI K	\mathbf{v}	101	w	14	UUU4

Wednesday, November 26, 2014 7:24:31 AM Item ID: D3575-5 Accept *N900040100* Setup Start **Revision ID:** Cargo Floor Protector Item Name: Start Oty: 1.00 **Start Date:** 11/26/2014 **Cust Item ID: Required Date:** 11/26/2014 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start Process Plan: MUS Date: 14-11-26 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty Code Qty Stamp **Run Hours** Number Draw Nbr **Revision Nbr** D3575 Rev A 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo 1-Cut as per Dwg D3575 Dwg Rev: A Prog Rev: A 2-FLOW CNC Waterjet Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC 0.00 Memo Quality Control DAS 120 QC8- Inspect parts - second check 0.00

QC

Quality Control

Memo

0.00

Page 1

DQA:			Date:				_							TRAG
QA Closed:			Date:			WORK ORDER NON	-C(ONFOI	RMANCE / U	UPDATE	Wo	ork Order up	odate only	AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
WOIN OIGE					_	Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	\vdash	Pro	d. Eng. Coor.	Quality
				· · · · · · · · · · · · · · · · · · ·		Use-as-is			noforming	Finishing	-	1	re/Packaging	Other
NCR N	۱٥					Suspected Unapproved	ed Unapproved Large Fab Composite Supplier							
Root					Descr	L ription of work order update	ı	initial	A	ction		Sign &		
Cause	(Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	QC Inspector
Design														
Doc/Data														
Equip/Tooling		,												
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport							1							
Unapproved														
							FA	ULT CA1	regory					
Landir	ng Gea	r				General		_				-		_
	Be	nding			<u> </u>	Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Ce	ntre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
1	Cra	acks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct	Temperature/Cure
	Cri	mp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/	Unqualified		Part Lost/Mi	ssing	Weld
	Cu	ffs				Contamination		Instruct	ions Incomplete	e/Unclear		Part Moved		Wrong Stock Pulled
	Cru	ushing				Countersink		Misalig	gned/off center	r		Positioned V	Vrong	_
50."	He	at Treat	t			Cut Too Short		Mislabe	eled			Power Loss/:	Surge	Other
Marry	Ins	pection	Strip in	Tube		Drawing		Misread	i i					
	Ma	arks/Cha	atter			Drill Holes		Off-set						
	Tu	rning Se	quence			Finish		Out of 0	Calibration					
	T _{\\\\}	ave/Twi	st in Tub	ne		Fit/Function	Г	Out of	Sequence					

150

Packaging

Packaging

Wednesday, November 26, 2014 7:24:31 AM Item ID: D3575-5 Accept Setup Start *N900040100* **Revision ID:** Cargo Floor Protector Item Name: 11/26/2014 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date:** 11/26/2014 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date: QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. **Work Center ID** Description Qty Number Stamp Code **Qty Run Hours** 130 0.00 Small Fab *130* Small Fab Deburr if necessary. Small Fab __ 140 QC5- Inspect part completeness to step on W/O 0.00 *140* QC 0.00 Memo Quality Control 150 Identify as per dwg & Stock Location: DAS

0.00

Memo

@6

9-69

DQA:		Date:			WORK OPDER NON	-C	CONFORMANCE / UPDATE					
QA Closed:		Date:			WORK ORDER NOW	-((JINFO	AWAINCE / C		Vork Order up	date only	AEROSPACE
Work Orde					DISPOSITION			,	AGAINST D	EPARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
Root			T	Desci	ription of work order update	ı	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or non-conformance	i	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
						FAI	ULT CAT	regory				
Landii	Cracks Crimp/k Cuffs Crushin	Not Concer Not (ink/Ripple B Beat on Strip in	·/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct	ion Incomplete/Lions Incomplete, aned/off center aled	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Sequence			Finish		4	Calibration			·	
	Wave/T	wist in Tul	эe		Fit/Function	1	Out of Sequence					

	Work Order ID 126802 Wednesday, November 26, 2014 7:24:31 AM			*126802*						Page 3		
Revision ID:	D3575-5 Cargo Floor P	rotector		Accept	*N900	<u>040</u>	100)* s	Setup Star	IV	S1* S2*	
Start Date: Required Date: Reference:	11/26/2014 Start Qty: 1.00 11/26/2014 Req'd Qty: 1.00		*1* *1*		Cust Item ID: Customer:							
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Star Sto	1/	R1* R2*	
Sequence ID/ Work Center ID)	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*160 *160* QC Quality.Control	-	Memo		0.00					14	12	Z PJ	
			-				<u>.</u> *.	~ · _	· ·-		nu - 14-11-2	

DQA:			Date:	**									DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / L				AEROSPACE
QA Closed:	_		Date:		<u> </u>				 .	V	ork Order up	date only	
Work Orde	er:					DISPOSITION				/PROCESS	:		
	-					Rework			Skid-tube Crosstube Water Jet				Engineering
Part N	۱o.					Scrap			Machining Small Fab Prod. Eng. Coor.				Quality
	_					Use-as-is		Thern	Thermoforming Finishing Rec/Store/Packagi				Other
NCR No.						Suspected Unapproved		Large Fab Composite]	Supplier		
Root					Descr	ription of work order update		nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design													
Doc/Data	_												
Equip/Tooling	_												
Handling/Pre	_												
Material	_												
Operator	_						ŀ						
Offset/Setup	_												
Process	_		!										
Supplier	_												
Training	_												
Transport	_												
Unapproved							<u> </u>						
							FAI	ULT CAT	EGORY				
Landir					·	General		,			_		7
	[6	Bending				Bend		1	rogram	_	Outside Dim	ensions	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	et .	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		inspecti	on incomplete/L	Jnqualified	Part Lost/Mi		Weld
	_	Cuffs				Contamination		1	ions Incomplete/	 	Part Moved		Wrong Stock Pulled
ļ		Crushing				Countersink		Misalig	ned/off center		Positioned V		_
ļ	Heat Treat Cut			Cut Too Short		Mislabe	led	L	Power Loss/	Surge	Other		
				Drawing		Misread	d						
	Marks/Chatter Drill I		Drill Holes		Off-set								
	_	Turning Se				Finish		Out of (Calibration				
	\	Wave/Tw	ist in Tub	e .		Fit/Function	L	Out of 9	Sequence				

Picklist Print

Wednesday, November 26, 2014 7:24:38 AM

Work Order ID: 126802

126802

Parent Item:

D3575-5

D3575-5

Parent Item Name: Cargo Floor Protector

Start Date: 11/26/2014

**

Required Date: 11/26/2014

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07.07.23

verified by:JLM

Component Item ID/ Replacement Mfg/ Qty per Kit Total Bin Primary Last Route Unit of Qty on Qty Date Status Item Name Item Location Location Seq ID Item ID Purch Measure Hand Qty Issued Issued MLEXS.125-F60029-04 Purchased No 100 sf 4,718.687 10.666 12

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code	
MAT019	2158.68738		
124866	106		
m126425	160.925		
m127934	665		
m128746	80.505		
m129759	1146.25738		10.666
SABIC	2560	-	
m130209	2560		

DQA:		Date:			WORK ORDER MON	WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:		Date:			WORK ORDER NON	-((JINFUI	RIVIAINCE / U		Wo	ork Order up	odate only	AEROSPACE	
Work Orde	r·				DISPOSITION				AGAINST	DĘ	PARTMENT,	/PROCESS		
Part N	0.				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		b Prod. Eng. Coor. g Rec/Store/Packaging		d. Eng. Coor.	Engineering Quality Other		
Root				Desc	ription of work order update		Initial Action		Sign &					
Cause	Cause Date Step Qty			or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector		
design doc/Data quip/Tooling landling/Pre Material Operator Offset/Setup rocess upplier raining ransport			,			EAL	ULT CAT	EGORY						
Landin	a Goor					FAI	ULI CAI	EGURT						
Landin	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch	t n Strip in atter equence	:/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/U ions Incomplete/ ned/off center eled d Calibration	/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
,	Wave/Tw	ist in Tuk	ne .		Fit/Function	1	Out of 9	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order: 17.6.802	
Description: Cabin Floor Protector	Part Number: D3575-5	
Inspection Dwg: D3575 Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	_		Method of	-
Dimension	rolerance	Dimension	Accept	Reject	Inspection	Comments
Ø3.00	+0.006/-0.001	Ø 3.00	/		Tape	
3.38	+/-0.030	3.38			V= pc-02	
6.50	+/-0.030	6.50	/	_		
26.13	+/-0.030	26.13	/			
30.13	+/-0.030	30.13	/			
2.00	+/-0.030	2.00	/			
3.50	+/-0.030	3.50				
14.25	+/-0.030	14.25	1	7.1		···
25.13	+/-0.030	25.13				
29.38	+/-0.030	29.38		<u> </u>		
30.38	+/-0.030	30.38		1111		
31.50	+/-0.030	31.50	/			
1.00	+/-0.030	1.00				
4.38	+/-0.030	4.38	/			
14.50	+/-0.030	14.50	1	100		
16.00	+/-0.030	16.00	_	·		
23.13	+/-0.030	23./3	7	·	· · · · · · · · · · · · · · · · · · ·	
26.88	+/-0.030	26.88				
27.69	+/-0.030	27.67	~			
1.00	+/-0.030					
3.75	+/-0.030	1.00	レ			
9.63	+/-0.030	3.75				
16.13	+/-0.030	9.63				
28.06		16./3		-		
	+/-0.030	28.06				
32.15	+/-0.030	32.15				

Measured by: Date: Audited by: 38

Date: 14/11/26

Date: NOV 2.7 2014

Rev Date Change

Audited by: 38

Prototype Approval: N/A

N/A

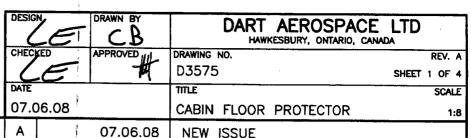
Page Approved

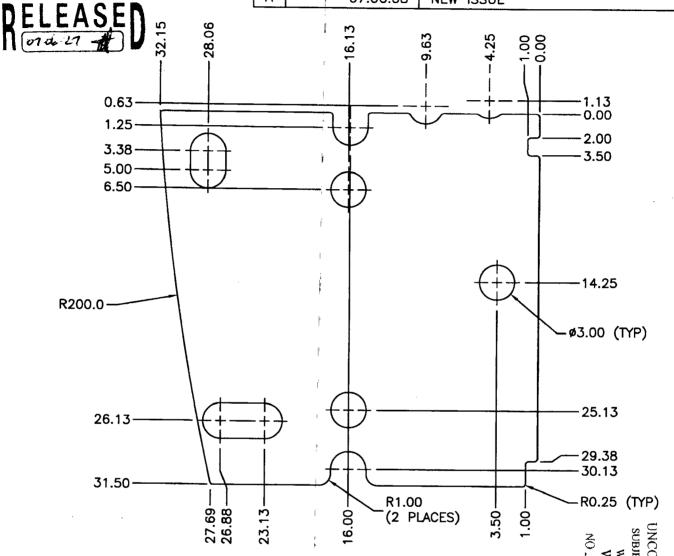
Rev
Date
Change
Revised by
Approved

A
08.01.16
New Issue
KJ//DD

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D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE

NOTES:

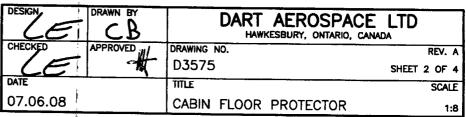
- WITHOUT NOTICE 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

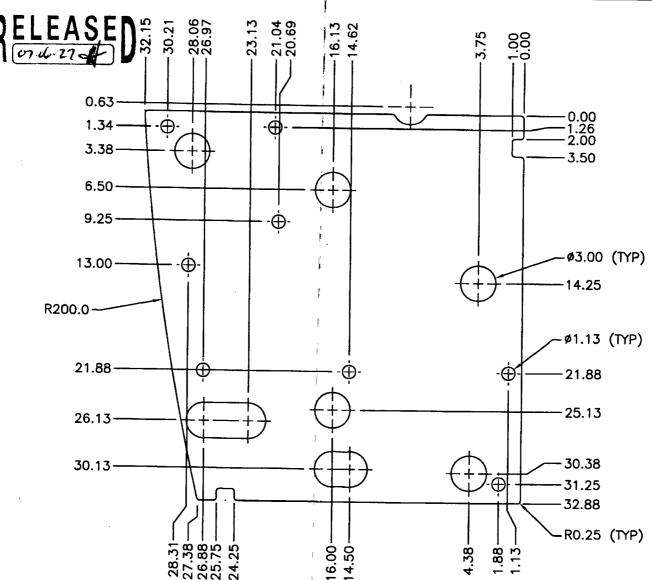
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D3575-3 CABIN FLOOR PROTECTOR

NOTES:

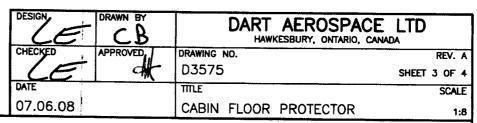
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

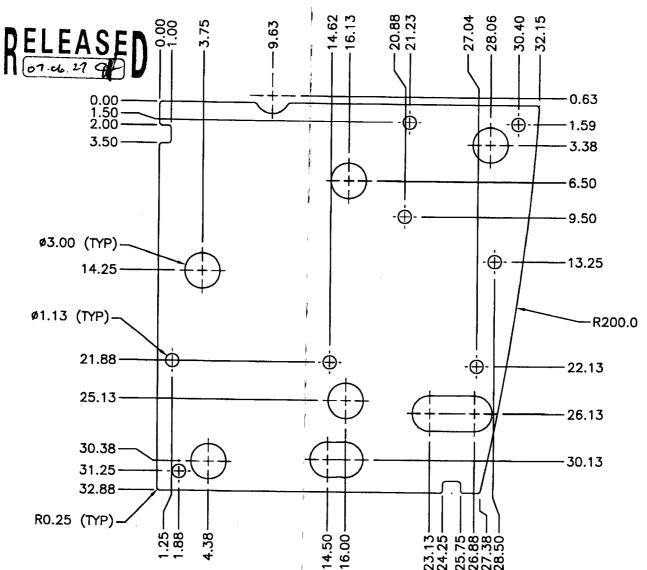
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D3575-4 CABIN FLOOR PROTECTOR

NOTES:

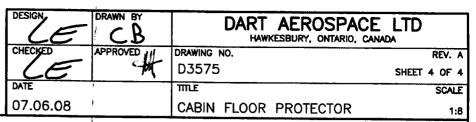
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

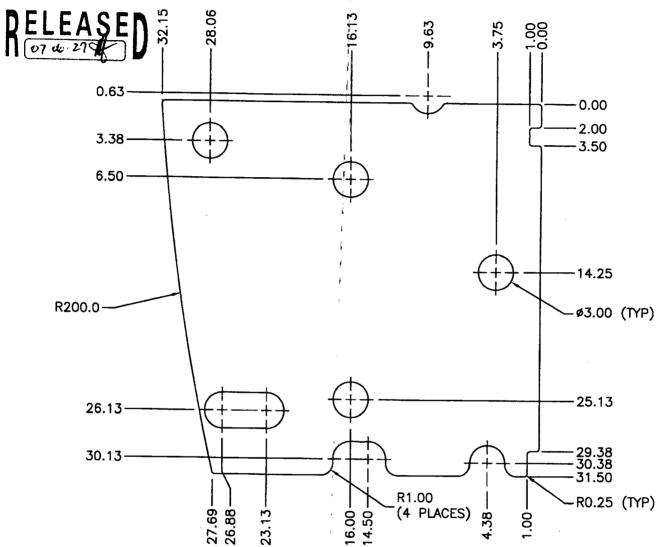
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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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